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D4148-1

Job Sheet 186658



Part No: D4148-1

Job Qty: 20 ea

Part Name: Crosstube Lug Plate, Fwd



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/19/18

Job Tracking No:

Due Date: 12/7/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV E SHEET 1 IPP Rev:A 10.06.24 new issue DD verf:EC IPP Rev:B 10.10.29 as per revC DD verf:EC
IPP REV:C 11.03.02 AS PER DWG REV.D DD VERF:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	20 pcs	12/7/18	12/7/18	0.06	4.31	Waterjet - Flow		SL 18/12/04
110	QC	20 pcs	12/7/18	12/7/18	0.00	0.00	QC2 Waterjet-3		DAS
120	QC	20 pcs	12/7/18	12/7/18	0.00	0.00	QC8-4		JAN 02 2019 68
150	Packaging	20 pcs	12/7/18	12/7/18	0.00	0.00	Packaging3	51080	JAN 03 2019 9-89
160	QC21-SA	20 Ea	12/7/18	12/7/18	0.00	0.00	QC21		9-89 21 JAN 03 2019

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S11GA	304/316 0.125 Sheet	7.2140 sf (.3607 ea)	100-Waterjet - Flow - 1	5114858 512784

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S11GA	7	40	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Fwd Crosstube Lug Plate	0.129Inches + 0.005 - 0.001	0.134 0.128	0.131	
2	Fwd Crosstube Lug Plate	0.191Inches + 0.005 - 0.001	0.196 0.190	0.192	
3	Fwd Crosstube Lug Plate	0.380Inches + 0.006 - 0.001	0.386 0.379	0.379	
4	Fwd Crosstube Lug Plate	0.257Inches + 0.006 - 0.001	0.263 0.256	0.258	
5	Fwd Crosstube Lug Plate	0.500Inches + 0.008 - 0.001	0.508 0.499	0.498	
6	Fwd Crosstube Lug Plate	0.940Inches ± 0.030	0.970 0.910	0.937	
7	Fwd Crosstube Lug Plate	4.470Inches ± 0.030	4.500 4.440	4.469	
8	Fwd Crosstube Lug Plate	0.750Inches ± 0.010	0.760 0.740	0.751	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		MRB (QSI042) Approval					
Description Work Order Deviation								Inspector: _____ Exp Date: _____ Instructions: Various STC's Date: 12/08/18 Part: D4148-1 Job No: 186658 Serial No/Batch: S135826 Revision: _____	
Root Cause								Inspector: _____ Exp Date: _____ Instructions: Various STC's Date: 12/08/18 Part: D4148-1 Job No: 186658 Serial No/Batch: S135826 Revision: _____	
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Wrong	☐		
Design	☐	Operator	☐	Bending	☐	tensions	☐		
Doc/Data	☐	Offset/Setup	☐	Centre Not Conc	☐	r tolerance	☐		
Equip/Tooling	☐	Supplier	☐	Cracks	☐	ect	☐		
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Missing	☐		
Material	☐	Use for Testing	☐	Cuffs	☐	Out of Sequence	☐		
Internal Transport	☐	Poor Information	☐	Crushing	☐	Off-set	☐		
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Mislabeled	☐		
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Fit/Function	☐		
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Misaligned/off center	☐		
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :					
Misidentified	☐	Past Due	☐						

9	Fwd Crosstube Lug Plate	8.470Inches ± 0.030	8.500 8.440	8,466
10	Fwd Crosstube Lug Plate	8.096Inches ± 0.010	8.106 8.086	8,095
11	Fwd Crosstube Lug Plate	5.430Inches ± 0.030	5.460 5.400	5,427
12	Fwd Crosstube Lug Plate	5.197Inches ± 0.010	5.207 5.187	5,195
13	Fwd Crosstube Lug Plate	4.733Inches ± 0.010	4.743 4.723	4,730
14	Fwd Crosstube Lug Plate	0.310Inches ± 0.010	0.320 0.300	0,311
15	Fwd Crosstube Lug Plate	0.750Inches ± 0.010	0.760 0.740	0,747
16	Fwd Crosstube Lug Plate	0.375Inches ± 0.010	0.385 0.365	0,373
17	Fwd Crosstube Lug Plate	1.840Inches ± 0.030	1.870 1.810	1,842
18	Fwd Crosstube Lug Plate	0.920Inches ± 0.030	0.950 0.890	0,923
19	Fwd Crosstube Lug Plate	3.000Inches ± 0.010	3.010 2.990	3,003
20	Fwd Crosstube Lug Plate	0.750Inches ± 0.010	0.760 0.740	0,749
21	Fwd Crosstube Lug Plate	0.625Inches ± 0.010	0.635 0.615	0,628
22	Fwd Crosstube Lug Plate	1.982Inches ± 0.010	1.992 1.972	1,980
23	Fwd Crosstube Lug Plate	0.991Inches ± 0.010	1.001 0.981	0,990
24	Fwd Crosstube Lug Plate	0.770Inches ± 0.030	0.800 0.740	0,771
25	Fwd Crosstube Lug Plate	1.540Inches ± 0.030	1.570 1.510	1,538
26	Fwd Crosstube Lug Plate	2.470Inches ± 0.030	2.500 2.440	2,472
27	Fwd Crosstube Lug Plate	0.820Inches ± 0.030	0.850 0.790	0,818
28	Fwd Crosstube Lug Plate	3.570Inches ± 0.030	3.600 3.540	3,569
29	Fwd Crosstube Lug Plate	1.230Inches ± 0.030	1.260 1.200	1,232
30	Fwd Crosstube Lug Plate	0.730Inches ± 0.030	0.760 0.700	0,734
31	Fwd Crosstube Lug Plate	0.125Inches ± 0.010	0.135 0.115	0,116
32	Fwd Crosstube Lug Plate	0.252Inches + 0.030 - 0.000	0.282 0.252	0,253

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				